

Work Order ID 122718

Tuesday, July 22, 2014 8:44:34 AM

122718

Page 1

Item ID: D3255 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Gasket

Start Date: 7/21/14 Start Qty: 50.00 *50*

Required Date: 7/21/14 Req'd Qty: 50.00 *50*

Reference: Cust Item ID:

Customer:

Approvals: Process Plan: MLJ Date: 14-07-23 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3255	Rev B								

100 PURCHASING 0.00

100

Purchasing

Purchasing

Memo

Issue P/O: 25136

Possible Supplier: Mc Master Carr

P/N: 8612K61

Material: Silicone coated fiberglass cloth per AMS 3320F SIL/36' x 36' x 1/16"

Certificat of conformaty required

CD 14/07/24 54

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Packaging

Memo

Ensure Material Release Note is attached

0.00

14/7/28 (24)

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 122718

122718

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Tuesday, July 22, 2014 8:44:34 AM

Item ID: D3255

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Gasket

Start Date: 7/21/14

Start Qty: 50.00

50

Cust Item ID:

Required Date: 7/21/14

Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

DAS
16
9-89

14/7/31

120

QC

Memo

0.00

Quality Control

x4
Rolls

130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

WATERGEL

0.00

Packaging

14/7/31 24

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

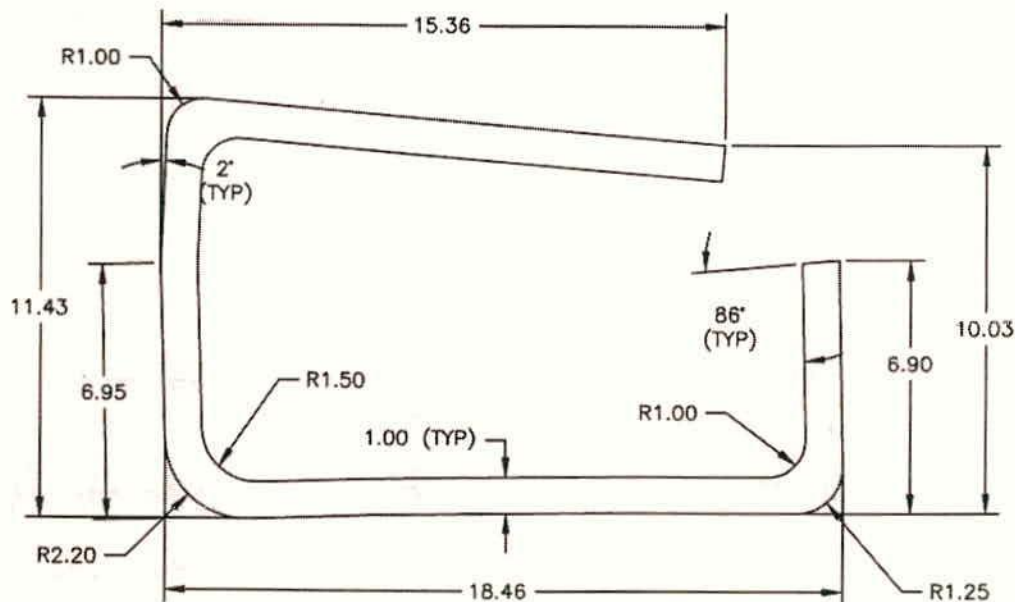
0.00

Quality Control

14/7/31

DART

DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05.01.18 JF**D3255-5 GASKET****D3255-5 NOTES:**

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO25136

Purchase Order Date 7/24/2014

PO Print Date 7/24/2014

Page Number 2 of 4

Order From :

VU-MCM001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

Contact Name

Buyer

Chantal Lavoie

Vendor Phone

330 995 5500

Customer POID

Ship To Contact

Customer Tax #

10127-2607

Ship To Phone

Terms

Net 10

Ship Via:

Purolator ground ppd

Currency

USD

Ship Acct:

FOB

FCA - (Free Carrier)

Line Total: \$54.72

4 SIL/F36X36X1/16

Gasket

7/28/2014

54.00 ✓

\$11.93

\$643.95

Yes

7/28/2014

sf

Nec 30

AS PER DWG D3255 REV.B
B122718
MCMaster P/N: 8612K61
54 SF = 9 ROLLS OF 24" X 36"

PO 64/7/20 Nec 27

Line Total: \$643.95

5 71475-10

8837K216 NEOPRENE
RUBBER

7/28/2014

1.00 ✓

\$63.98

\$63.98

Yes

7/28/2014

Each

Line Total: \$63.98

Deliver To: david.d

6 71400-20

9199K27
TEMP/HUMIDITY
LOGGER

7/28/2014

1.00 ✓

\$234.00

\$234.00

Yes

7/28/2014

Each

P 19/7/20

Note:

7/24/2014



Purchase Order
PO25136

Page 1 of 2

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Order Placed By
Chantal Lavoie

07/24/2014

McMaster-Carr Number
6762542-01

Line	Description	Ordered	Shipped				
4	8612K61 Fiberglass Fabric-Reinforced Silicone Rubber, Plain Back, 1/16" Thick, 24" X 36" Your Part Number: B122718	9 Each	4	8 - 36 - 49	45 - 78	K61	4EA
				11 lbs			

Gx 4x

Shipped separately from our Cleveland warehouse on 07/24

1	1722A42 Tool Holder, Nickel-Plated Steel, for 5/16" - 3/4" Tool Diameter	5 Packs	5				
2	8672K31 UHMW Polyethylene Trim, Screw Mount, U-Shape, 1" Inside Width	40 Feet	40				
3	9928K53 Impact-Resistant UHMW Polyethylene U-Channel, 1" Base X 3/4" Legs, 1/4" Thick	24 Feet	24				
4	8612K61 Fiberglass Fabric-Reinforced Silicone Rubber, Plain Back, 1/16" Thick, 24" X 36"	9 Each	5				
5	8837K216 Nonmarking Neoprene Rubber, 1/4" Thick, 12" X 24", 50 Durometer, Black	1 Each	1				
6	9199K27 Temperature/Humidity Logger, -22 to +122 Degree F, 5-95% Relative Humidity	1 Each	1				
7	5763T13 Security and Admittance Sign, 18" X 24", Aluminum, "Notice This Property Is. ..."	2 Each	2				

Dart Aerospace Ltd

EXP



11 lb
1 lin

EW1UPP32
07/24/2014
11:58/13:32
698
Cycle 39

1141200334326



MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D3555 /
 DATE: 2004/07/31

PO / BATCH NO.: B 122718
PO# 25136

MATERIAL CERT REC'D: 34' yes
 QUANTITY RECEIVED: 54' (+4 Reels)
 QUANTITY INSPECTED: 54'
 QUANTITY REJECTED: 0

THICKNESS ORDERED: 1/16"
 THICKNESS RECEIVED: 0.063"
 SHEET SIZE ORDERED: 36' x 36'
 SHEET SIZE RECEIVED: 36' x 36'

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	<input checked="" type="checkbox"/>	
CORRECT FINISH	<input checked="" type="checkbox"/>	N	
CORROSION	Y	<input checked="" type="checkbox"/>	
CORRECT GRAIN DIRECTION	<input checked="" type="checkbox"/>	N	
CORRECT MATERIAL	<input checked="" type="checkbox"/>	N	
CORRECT THICKNESS	<input checked="" type="checkbox"/>	N	
PHOTO REQUIRED	Y	<input checked="" type="checkbox"/>	
CORRECT MATERIAL	<input checked="" type="checkbox"/>	N	<u>* P/N 8612K61</u>
CORRECT REF # TO LINK CERT	Y	N	<u>PO# 25136</u>
CORRECT MATERIAL IDENTIFICATION	Y	N	<u>D3555 B 122718 Reel B</u>
CORRECT M# ON THE MATERIAL	Y	N	<u>B 122718</u>
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	<input checked="" type="checkbox"/>	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	<input checked="" type="checkbox"/>	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL SIZE OF TEST SAMPLE HARDNESS / DUROMETER READING	HRC	HRB	DUR A	DUR D	

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>DAS</u>		SIGNED OFF BY: _____	
DATE: <u>16 0-89 14/07/31</u>		DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORRECT TO THE DART PO INSTRUCTIONS
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN 20pcs FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIREMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIREMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b. OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC COORDINATOR BEFORE GOING FURTHER